Work Orde Monday, April 0-										· .		Page 1
Revision ID:	D3280-1L02				Accept				s s	Setup Sta		
	Floor Protecto 4/4/2011 4/6/2011	or, LH Start Qt Req'd Q	-			Cust Item Customer:	ID:				⁹ 	
Approvals:	Process Pla	ın:	-pl	Date: LOHLY	Tooling: SPC (Y/N):		ate:	 	R	tun Sta Sta		
Sequence ID/ Work Center II)	Operatio Descripti			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3280		rision Nbr DE H.	11/04/0	4								
100 Thermoform Thermoforming Mac	chine	HAND FIN	ISHING THE Memo Cut Blanks	ERMOFORMING	0.00				×4			Dh 11/04/12
105 HandThermo Hand Finishing Ther	moforming	Dry Materia	Memo	sper QS1022 POLYCARBO 140°1° 4;00 pm 7:00 am	1				×4.	-	-	11/04/12

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W/O:			W	ORK ORDER CHANG	ES		·,···		<u> </u>
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	4:	Date:	
•	R	esolution:	Disposit	ion:	_ QA: N/C (Closed:		Date:	
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NC	R)			
DATE	CTED	Description of NC		Corrective Action Secti		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
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Work Order ID 67914

Monday, April 04, 2011 2:55:37 PM



Page 2

Item ID:

D3280-1L02

Accept



Setup Start

Stop



Revision ID:

Item Name:

Floor Protector, LH

Start Date:

4/4/2011

QC:

Start Qty: 4.00

Required Date: 4/6/2011

Req'd Qty: 4.00



Cust Item ID:

Tool ID

Customer:

Reference:

A	nr	ro	va	ls:
. n.	rr	,, ,	7 44	13.

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Tool # Plan

Code

Date:

Run Start

Reject

Qty

Stop

Reject

Number



Insp.

Stamp

Sequence ID/ Work Center ID

110

Thermoform

Thermoforming Machine

Operation Description

Set Up/ Run Hours

0.00

THERMOFORMING MACHINE

Memo

0.00

Thermoform as per Dwg. D3280 and Folio FTA 011

Dwg. Rev. Folio Rev.

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Accept

Qty

130

120

Thermoform

Quality Control

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

0.00

0.00

Trim to Finished Dimensions

		— ·								₹
W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR:	Yes N	lo DQ	A:	Date: _	
	R	esolution:	Disposition	on:	QA: N	VC Clo	sed:		Date: _	
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (NCR)	١			
DATE	CTED	Description of NC			tion B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	,	Sign & Date		ion C	Chief Eng	QC Inspector
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Work Order ID 67914

Monday, April 04, 2011 2:55:37 PM



Page 3

Item ID:

D3280-1L02

Accept

Setup Start



Revision ID:

Item Name:

Floor Protector, LH

Start Date: Required Date: 4/6/2011

4/4/2011

Start Oty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

	_	
A	pprovals:	

Process Plan: _____

Date:

Tooling:

Date:

Run

Start

Stop

Stop

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Accept

Reject Qty

Reject Number

Insp.

Sequence ID/ Work Center ID

140

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Tool ID

Tool # Plan

Code

Qty

Stamp

150

Quality Control

QC5- Inspect part completeness to step on W/O

160

Packaging Packaging

Packaging

Memo

Memo

0.00

0.00

	-									4
W/O:			W	ORK ORDER CHANG	ES	1				
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	·						*************************************			
Part No	:	PAR #:	Fault Cat	tegory:	_ NCF	R: Yes	No DQ	A:	Date:	
	Re	esolution:							Date: _	
NCR:		•	WORK ORI	DER NON-CONFORMA	NCE	(NCR	1)			
DATE	STEP	Description of NC		Corrective Action Section	on B		Verifi	cation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	tion C	Chief Eng	QC Inspector
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W	ork	Ord	ler ID	679	14
77	UIK	viu	161 ID	' U/7	14

Monday, April 04, 2011 2:55:37 PM



Page 4

Item ID:

D3280-1L02

Accept



Setup Start

Stop



Revision ID:

Item Name:

Floor Protector, LH

Start Date:

Required Date: 4/6/2011

4/4/2011

Start Qty: 4.00

Req'd Qty: 4.00



Date: _____

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

SPC (Y/N):

Date:

Date:

Start

Run

Stop



Sequence ID/

Work Center ID

QC:

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

170

Memo

0.00

Quality Control

WF 75

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W/O:			V	ORK ORDER CHANG	GES				
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:	-	W	ORK OR	DER NON-CONFORM	IANCE (NC	R)			
DATE	STEP	Description of NC			ction B		cation	Approval	- Approval
	O I L I	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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_									

Picklist Print

Monday, April 04, 2011 2:55:43 PM

Work Order ID: 67914

Parent Item:

D3280-1L02

Parent Item Name: Floor Protector, LH



Start Date: 4/4/2011

Required Date: 4/6/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev. C Revised to add color sheet. 11/03/02 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02	8118 18188 1111 1188188 1118 8111 1	Purchased	No			100	sf	808.4400	4.333	18.24421			Sh
GE PLASTICS LEXAN SH	ce i			<u>Location</u>		<u>Loc (</u>	<u>Otv</u> 8 44	Loc Code					reforti

Location Loc Qty Loc Code 808.44 therm 105.89 106751 702.55

18.24421 sq C4

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W/O:			WO	RK ORDER CHANGI	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				•						
Part No	:	PAR #:	Fault Categ	ory:	NCR:	Yes I	No DQ	A:	Date: _	
	R	esolution:	Disposition	·	_ QA: N	C Clo	sed:		Date: _	
NCR:				R NON-CONFORMA						
DATE	STEP	Description of NC		Corrective Action Section			Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		on C	Chief Eng	QC Inspector
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		·								
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DART AEROSPACE LTD)		Work Order:	67914
Description: R22 Floor Protect	ctor, LH		Part Number:	D3280-1
Inspection Dwg: D3280	Rev: D/ 2=	DC11/09/19		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	<u> </u>			
Shape Definition	-			
Texture Retention	レ			
Material imperfections such as bumps, cracks, voids, scratching	/			
Measured by:]		Date:	11/04/12

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.25")		IAPE OL-OL	
16.0	+/-0.100	15.94	1	-	APE DE-CL	
12.1	+/-0.100	12.1"	/		TAPE DL-CO	·
0.95	+/-0.030	0,959	-		Clera DL-02	
0.25	+/-0.030	0,259			1/am 02-02	
0.070	Min	0.075"	/		CAL TH-DT	
0.050	Min	0.056"	<u></u>		Voin 02-02	
					_	
						<u> </u>

Measured by:

Date: 11/04/19

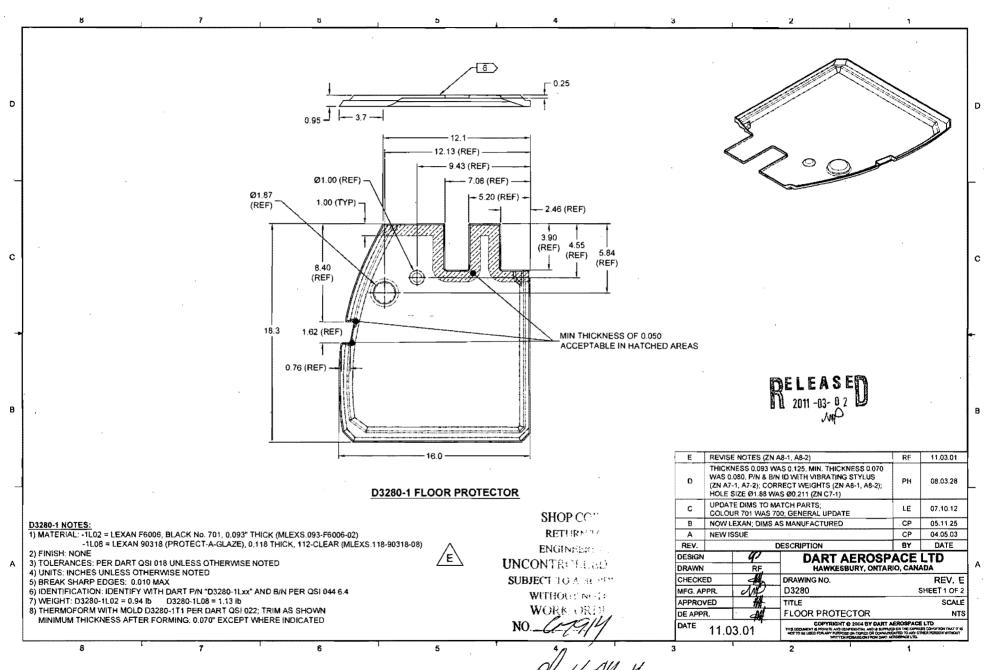
Date: 11/04/19

Date: N/A

Date: N/A

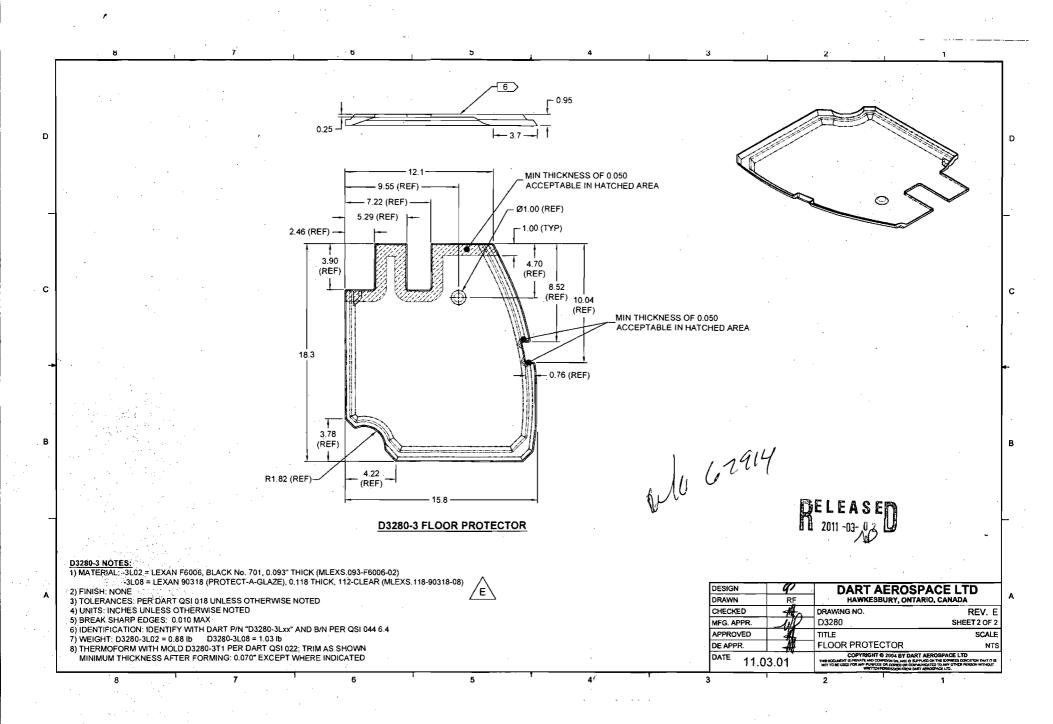
Rev	Date	Change	Revised by	Approved
Α	08.01.16	New Issue	KJ/DL LA	0.4
В	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	27

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W/O:	•		WORK ORDER (CHANGES			•		
DATE	STEP	PROC	EDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	- ,			No DQ/		Date: Date:	. · · · · · · · · · · · · · · · · · · ·

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE STEP		Description of NC	Corrective Action Section B			Verification	Annroyal	Ammuoval
		Section A			Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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W/O:			V	ORK ORDER CH	ANGES	<u> </u>				
DATE	STEP	PROC	PROCEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	_ Fault Ca	tegory:		NCR: Yes	No DQ	A:	_ Date: _	
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NCR:		W	ORK OR	DER NON-CONFO	RMAN	CE (NC	R)			
DATE STEP		Description of NC Section A	Initial Chief Eng			Sign Dat	& Sect	cation tion C	Approval Chief Eng	Approval QC Inspector
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